

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS		
Job Number	: 32551				
Estimate Number	: 10104				
P.O. Number	: N/A	Part Number	: D2012107		
This Issue	: 5/25/2007	S.O. No.	: N/A	Drawing Number	: D2012-107 REV. C
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: N/A	Type	: SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29883			Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 6/6/2007	Qty:	50 Um: Each
Checked & Approved By	: <u>[Signature]</u>				
Comment	: Est: D 01/11/08 Re-format, Drawing to Rev. C SM				
	: Est Rev:E Now on Waterjet 06-06-13 JLM				

Job Number:

Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
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98	1000	1000
99	1000	1000
100	1000	1000

10 M304S16GA 304/316 .063 Sheet

Comment: Qty.: 0.0146 sf(s)/Unit Total : 0.7298 sf(s)

304/316 .063 Sheet

(M304S063)

Batch: M103961

ml 01 06 09

50

2.0 WATER JET

FLOW WATER JET

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2012-107

Dwg Rev:

Proq Rev:

mm 01 06 09

2-Deburr if necessary

30 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0 .QC8

~~SECOND CHECK~~

Comment: SECOND CHECK

5.0 BRAKE NC

NC BRAKE

Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

ml 07/06/28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:01:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 32551

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count  
05/26/29 (50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

05/26/29 (50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(50)  
05/26/29

Job Completion



05/26/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

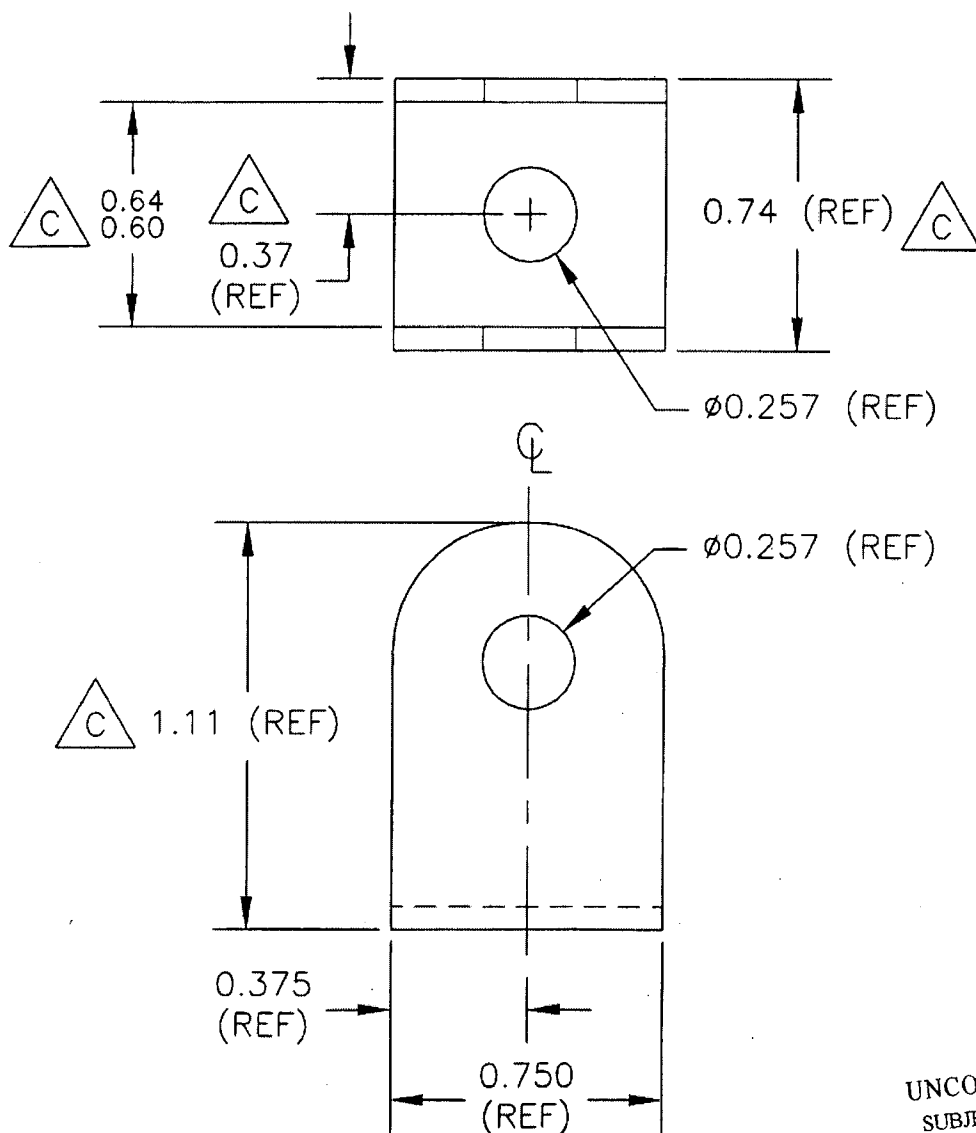
NOTE: Date & initial all entries





DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED  
00.01.04 DS



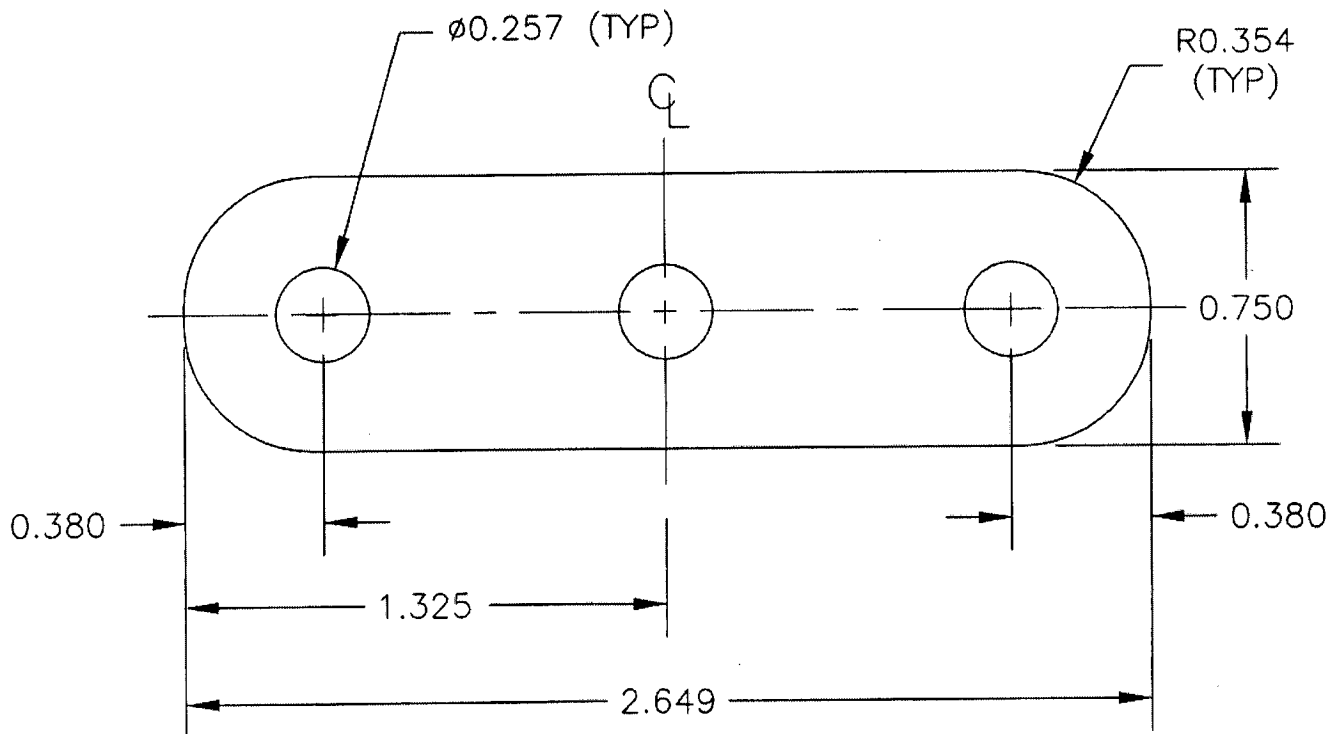
MATERIAL: AISI 304/316 SS 0.063 THICK  
USE 0.032 BEND RADIUS  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32551



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED  
00-01-04 PS



D2012-107 FLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32551

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES